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7393 Jan 6981

RBW6405G00531-3G
Job Sheet 186300



Part No: RBW6405G00531-3G Job Qty: 1 ea

Part Name: Tail Rotor Damper Length Adjustment Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 12/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6405G00531-3G Rev. A IPP Rev. A 18.06.13 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/10/18	12/10/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs	12/10/18	12/10/18	0.00	0.25	Small Fab-3		M.L.
120	QC	1 pcs	12/10/18	12/10/18	0.00	0.00	QC5		
130	Packaging	1 pcs	12/10/18	12/10/18	0.00	0.00	Packaging3-1		
140	QC21-SA	1 Ea	12/10/18	12/10/18	0.00	0.00	QC21		

Part Op Descriptions: 110 - 1-Press in bushings. 2-Fabricate lanyards. 3-Assemble as per DWG.

21
9-88 DEC 11 1988

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6405G00531-3G-1	Base	1 Ea (1 ea)	90-Start up Operation	510 7980
RBW6405G00531-3G-3	Pin	2 Ea (2 ea)	90-Start up Operation	5110 134
3896T31	Ferule 1/16 X 3/8" - Aluminum	4 Ea (4 ea)	110-Small Fab	5093315
90177A218	Split Ring	4 Ea (4 ea)	110-Small Fab	51090834
CL-2-C	Lanyard Wire	1.8000 ft (1.8 ea)	110-Small Fab	5119 833
PM-18-20-11	Bushing	2 Ea (2 ea)	110-Small Fab	5133 1670
				51219250

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6405G00531-3G-1	1	4	0
		2	8	0
		4	590	0
		4	138	0
		2	503	0
		2	8	0

Container No: S136480



Part: RBW6405G00531-3G

Job No: 186300

Serial No/Batch: S136480

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 12/10/18

itions

not be found.

Plex 11/14/18 8:28 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

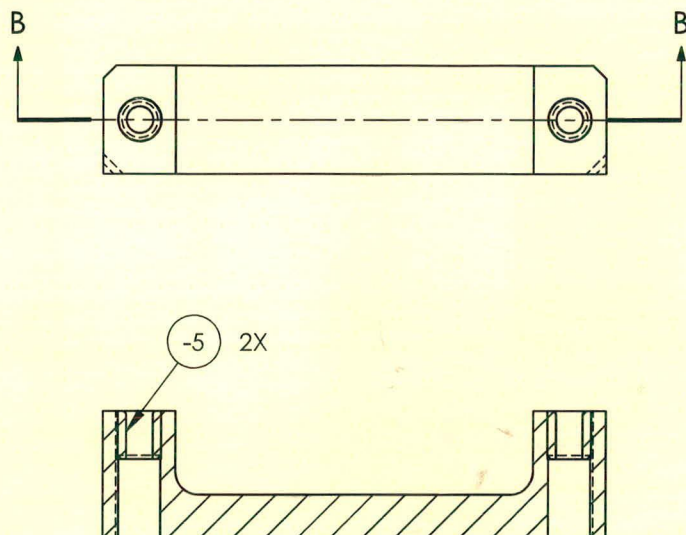
QA Closed: _____ Date: _____

Work Order update only ☐

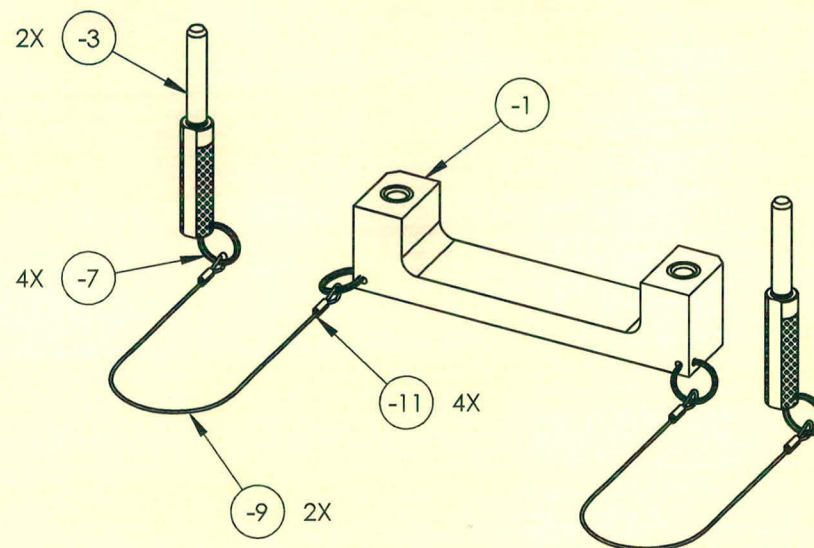
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D -7 WAS MCMASTER-CARR #90177A228 IS MCMASTER-CARR #90177A218. CH'D ENGRAVE NOTE WAS "3G6405G0251" IS "RBW6405G02051-3G".	2/5/2013	BIM	SE



SECTION B-B
SCALE 1 : 3



SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186300 MJS
18-11-14

RED BARN MACHINE	
TITLE T/R DAMPER LENGTH ADJUST	
DWG NO. RBW6405G00531-3G	REV A
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW139
SCALE 1:4	DATE 12/12/2012 SHEET 1 OF 3

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	6061	1-7/8 X 2-1/8 X 8-3/8	2
			-3	2	PIN	4140 Q & T	Ø3/4 X 5-1/4	3
		B/O	-5	2	BUSHING	STEEL	CARR LANE # PM-18-20-11	1
		B/O	-7	4	SPLIT RING	STEEL	Ø1 MCMASTER-CARR #90177A218	1
		B/O	-9	2	LANYARD	COATED STEEL	Ø1/16 X 10 CARR LANE #CL2C	1
		B/O	-11	4	FERRULE	ALUMINUM	Ø1/16 X 3/8 MCMASTER-CARR #3896T31	1

